

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021484**Date Inspected:** 06-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG & Tower**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector, Mike Hasler was present during the times noted above for observations and testing relative to the work being performed.

Bay 11

This QA inspector performed a random observation for the OBG. During the observation performed it was noted that at Bay 11 ZPMC was in process of welding and Heat Straightening. ZPMC QC inspector Shao Hai Lang was present at this time of this observation and informed this QA inspector of the work that is in process and identified Zhao Chen Sun as the CWI. It was stated that ZPMC had 3 welders and identified the welders by ZPMC welder identification number appointed to them by ZPMC. This QA inspector verified this information for the following location;

WR20365

Weld-20TR2-035-009

WPS-345-SMAW-2G(2F)-Repair

Welder-046769, 202354, 041271

2G/SMAW/CJP

HRS1 (B) 11680

WSD1-TPSA6-3 & ESD1-TPSA6-2

Bay 10

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This QA inspector observed ZPMC in process of FCAW welding on traveler rail assembly. ZPMC CWI Li Peng Fei was present at this time of this observation and informed this QA inspector of the work that is in process. It was stated that ZPMC had 3 welders and identified the welders by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

Weld- 28TR1-001-003, 006
WPS-B-P-2232-ESAB
Welder- 054069
2G/FCAW/CJP

Weld- 28TR1-001-009
WPS-B-P-2232-ESAB
Welder- 040367
2G/FCAW/CJP

Weld- 28TR1-001-012, 016
WPS-B-P-2232-ESAB
Welder- 040302
2G/FCAW/CJP

Bay 8

This QA inspector observed ZPMC personnel performing thermal cutting/ trimming of drip plate on bike path assembly BK004A-063 using mechanical guided track torch. The following digital picture illustrates thermal cutting in process.

Trial Assembly

This QA inspector ZPMC personnel performing tack welding of fit-up/ alignment aids on segment 12BW to 12CW, longitudinal floor beam on CW-side, welder 053697.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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Summary of Conversations:

“As noted within the contents of this report.”

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 1500026784, who represents the Office of Structural Materials for your project.

Inspected By:	Hasler, Mike	Quality Assurance Inspector
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Reviewed By:	Riley, Ken	QA Reviewer
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